

# Work Order ID 68494

Thursday, April 14, 2011 10:14:48 AM



Page 1

Item ID:	D2807-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Door prop					
Start Date:	4/14/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	4/21/2011	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-04-14	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2807	Rev E

100		0.00							
	PURCHASING								
Purchasing		0.00							
Purchasing	Memo								
	Issue P/O: 13449								
	<input type="checkbox"/> Order as per Dwg D2807								
	Possible supplier: Lift Support Technologies, Saskatoon, Canada								
	<input type="checkbox"/> P/N 6/15-164/50-115N								
	<input type="checkbox"/> Material release note is required								
110		0.00							
	Receive & Inspect for Damage & Mat'l Certs								
Packaging		0.00							
Packaging	Memo								
	Ensure Material Release Note is attached								
120		0.00							
	QC6- Inspect dimensions to drawing								
QC		0.00							
Quality Control	Memo								

11-04-14  
(20)

10/14/15  
(20)

count  
(x20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68494**

Thursday, April 14, 2011 10:14:48 AM



Page 2

Item ID: D2807-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door prop

Start Date: 4/14/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-install D3671-1 as per dwg D2807

4/14/2011 20

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/14/2011

count  
+20

150

0.00



Identify as per dwg &amp; Stock Location: 22

Packaging

Memo

0.00

Packaging

11/14/2011 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Thursday, April 14, 2011 10:14:48 AM



Page 3

Item ID: D2807-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door prop

Start Date: 4/14/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/27 *[Signature]*  
ME  
11-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 14, 2011 10:14:55 AM

Page 1

Work Order ID: 68494

Parent Item: D2807-041

Parent Item Name: Door prop



Start Date: 4/14/2011


Required Date: 4/21/2011


Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: D 07.11.12 ecn1019, replaces D2807 EC verified by DD  
IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3671-1  Placard		Manufactured	No			110	Each	6.0000	1	20			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		6							
					65325	6							
6/15-164/50-115N  Gas Spring		Purchased	No			130	Each	0.0000	1	20			

 4/14/2011  
B68630 (14x)

 4/14/10 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



# SPECIFICATION CONTROL DRAWING

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68494  
11-04-14

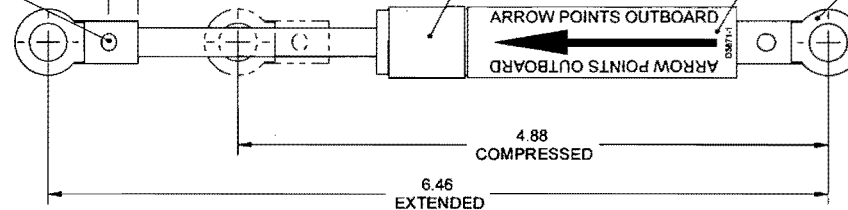
(ALTERNATE ONLY)  
CRIMP 0.015-0.025 DEEP  
WITH  $\varnothing 0.375$  TOOL AT  
2000psi (REF), TYP TWO  
SIDES PER LUG

0.24 TO CRIMP  
(TYP)

D2807-5  
OR  
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD  
ENSURE PLACARD DOES NOT  
CONCEAL ANY TEXT OR MARKINGS  
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3  
BOTH ENDS



**D2807-041 GAS SPRING**

RELEASED  
01-12-14

## D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)  
(WEIGHT: 0.176 LBS)

E	ADD D2807-5 GAS SPRING; D2807-11-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	4	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	#		
CHECKED	JE	DRAWING NO.	REV. E
MFG. APPR.	14	D2807	SHEET 1 OF 3
APPROVED	14	TITLE	SCALE
DE APPR.	#	GAS SPRING	NTS
DATE	07.12.28	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

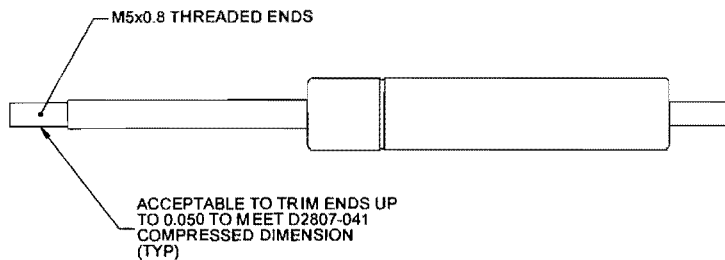
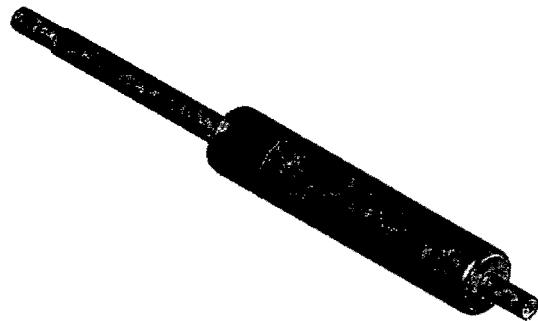
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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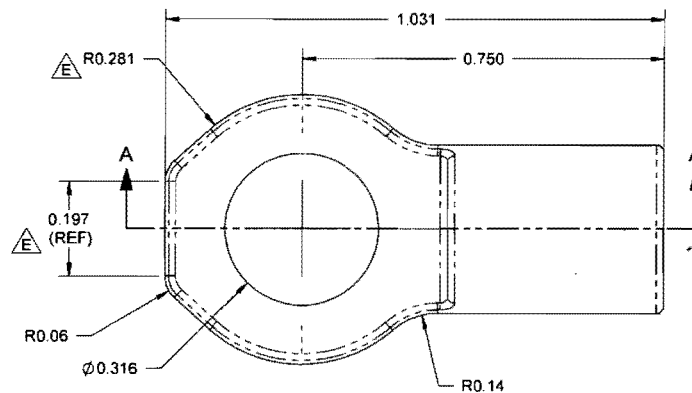
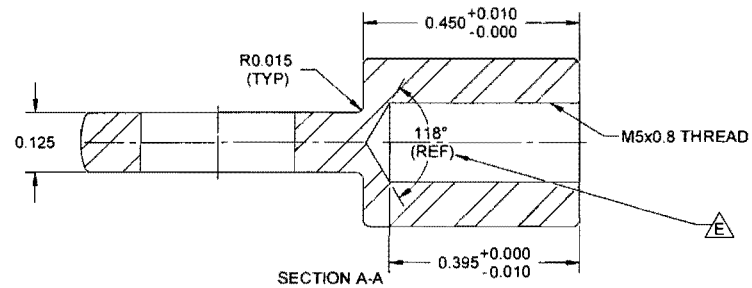
**NOTE:** Date & initial all entries



**D2807-1 GAS SPRING**  
SCALE 1:1

**D2807-1 GAS SPRING NOTES:**

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK  
(P/N SXF6S6050080S6L-115N)  
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX  
M5x0.8 THREADS



**D2807-3 LUG**

**D2807-3 LUG NOTES:**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

DESIGN	14	<b>DART AEROSPACE LTD</b>	
DRAWN	14	HAWKESBURY, ONTARIO, CANADA	
CHECKED	14	DRAWING NO.	REV. E
MFG. APPR.	14	D2807	SHEET 2 OF 3
APPROVED	14	TITLE	SCALE
DE APPR.	14	GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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w/o  
68494

RECEIVED

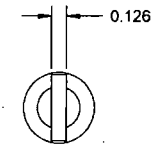
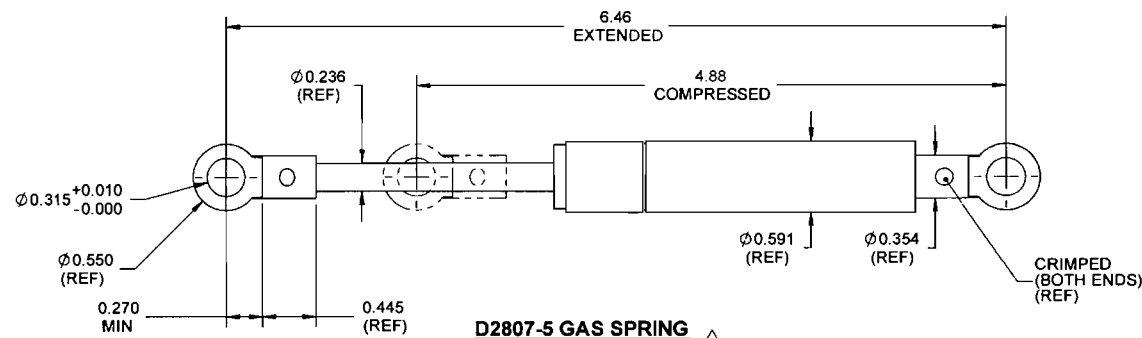
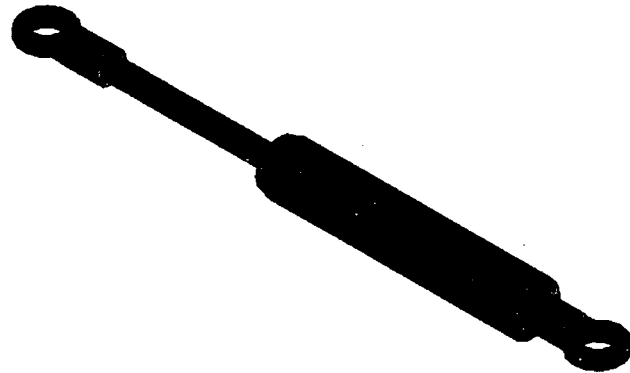
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



*u/b 68494*

*RELEASED*  
*08-02-12*

**D2807-5 GAS SPRING NOTES:**

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA  
(P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS,  
ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>KE</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>KE</i>	<b>D2807</b>	SHEET 3 OF 3
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	<b>GAS SPRING</b>	4:1
DATE	07.12.28	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO13869

Purchase Order Date 4/14/2011

PO Print Date 4/14/2011

Page Number 1 of 1

Order From :

VC-LST0001

LS TECHNOLOGIES INC.  
303-103 STREET  
SASKATOON, SK S7N 1Y9  
CA

FR  
APR 14  
2011

Contact Name

Vendor Phone

306 683 5000

Vendor Fax

306 683 6403

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	6/15-164/50-115N	Gas Spring	4/18/2011 Yes	20.00 Each	FedEx Overnight	\$63.9000	\$1,278.00
		Special Inst:	As per DWG: D2807 Rev: E B68494 LS Technologies P/N :6/15-164/50-115N				
2	B8-220-530-070N	CARBON STEEL GAS SPRING	4/18/2011 Yes	6.00 Each	FedEx Overnight	\$36.8500	\$221.10
		Special Inst:	As per DWG: D3552 REV: G B68506 LS Tech...P/N B8-220-530-70N				
PO Total:							\$1,499.10

Please send a confirmation

7969 899788 31

u p

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 4/14/2011





303 - 103 Street  
Saskatoon, SK Canada  
S7N 1Y9

Date	Invoice #
4/14/2011	7173

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

P.O. No.	Ship	Via	FOB	Project
13869	4/14/2011	Fed-Ex		

Qty	Description
20	6/15-164/50-115N ( D2807 Rev E ) Stainless Gas Spring
6	B8-220-530-070N Carbon Steel Gas Spring ( D3552 Rev G)
Shipping Via FED EX Tracking # 796989978831	





303 - 103<sup>rd</sup> Street, Saskatoon, Saskatchewan, Canada S7N 1Y9  
Ph: (306) 683-5000 Fax: (306) 683-6403

### Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

**20 Units: 6/15-164/50-115N ( D2807 Rev E ) Stainless Gas Spring**

**6 Units: B8-220-530-070N Carbon Steel Gas Spring ( D3552 Rev G)**

**Country of Manufacture: Canada**

**Date of Manufacture : April 2011**

**This product is ROHS compliant.**

**We certify no mercury was used in the manufacture of this order.**

Purchase Order # 13869  
Invoice # 7107

*S*  
*11/04/11*

L S Technologies Inc Canada

Nolan Fehr  
Manager

